

C5498792

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.



CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6498790

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	6 29 90	6 29 90	RW
600	Proof	6 29 90	6 29 90	RW
607	Check Headspace	6 29 90	6 29 90	RW
610	Dis-assemble Gun	6 29 90	6 29 90	RW
612	Magnaflux Barrel Action		7-12-90	BR
	Magnaflux Bolt		7-12-90	BR
615	Rollmark Caliber		7-12-90	BR
617	Drill and Tap Sight Holes		7/17/90	LB
618	Polish Barrel RB		7/16/90	WB
620	Apply Coatings (Barrel Action)		7-23-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		7/25/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/25/90	RW
	C) Inspect Ejector Hole for Chamfer		7/25/90	RW
	D) Oil Firing Pin Ass'y		7/25/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8-11-90	JL

BARBER - M24 0007811

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			8/2/90	921
	G) Safety Off Force	3	3	3			8/2/90	921
	H) Trigger Pull Test & Retainability						9-11-90	924
	I) Firing Pin Indent	.0225	.0225	.0225			8/2/90	921
	J) Assemble Stock						8/9/90	RW
	K) Assemble Swivel Studs						9/12/90	928
	L) Attach Front and Rear Sight Assemblies						8/9/90	RW
	M) Iron Sight Alignment						8/9/90	RW
	N) Detach Front & Rear Sights & place in numbered container						8/9/90	RW
	O) Attach Scope to Rifle						8/9/90	RW
	P) Detach & Attach Scope 20 Times						8/9/90	RW
640	Gallery Target & Test						8-13-90	KJ
	A) Time						8-13-90	KJ
	B) Malfunctions						8-13-90	KJ
	C) Pierced Primers						8-13-90	KJ
	D) Optical Clarity of Scope						8-13-90	KJ
645	Inspect for Live Ammo						8-13-90	KJ
655	Final Inspection							
	A) Headspace						9/12/90	928
	B) Trigger Pull	2.14	2.04	2.12	2.10	2.30	9-11-90	921
	C) Function						9/12/90	928
660	Pack						9/19/90	NF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6498790DATE 9-11-90TESTER JG

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.26	2.28	2.14	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.16	2.06	2.04	
PULL #3	2.30	2.21	2.18	2.12	
PULL #4	2.39	2.11	2.17	2.10	
PULL #5	2.39	2.28	2.23	2.30	
TOTAL	11.71	11.02	10.92	10.70	
AVG.	2.342	2.204	2.184	2.140	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.26		
PULL #2	3.38	3.28		
PULL #3	3.25	3.17		
PULL #4	3.30	3.26		
PULL #5	3.16	3.26		
TOTAL	16.28	16.23		
AVG.	3.256	3.246		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.16		4.13
PULL #2	4.20	4.20		4.15
PULL #3	4.20	4.22		4.08
PULL #4	4.19	4.21		4.10
PULL #5	4.23	4.15		4.15
TOTAL	21.18	20.94		20.53
AVG.	4.236	4.188		4.106

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6498790
13 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.931223
1 TO	2	1.85216
1 TO	3	1.53362
1 TO	4	1.41993
1 TO	5	1.26688

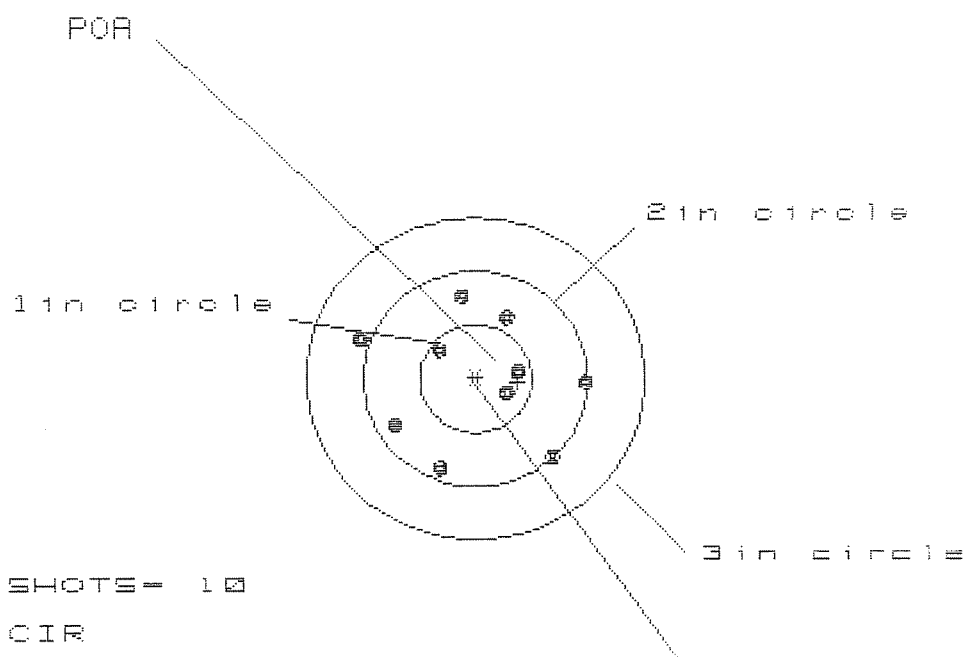
4
5+ <----POA
2 3 1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.3504
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1494
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .380921
THE AMR FOR THIS RIFLE IS: .8262

13 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6498790

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 1.998

VS= 1.532

GS= 2.091

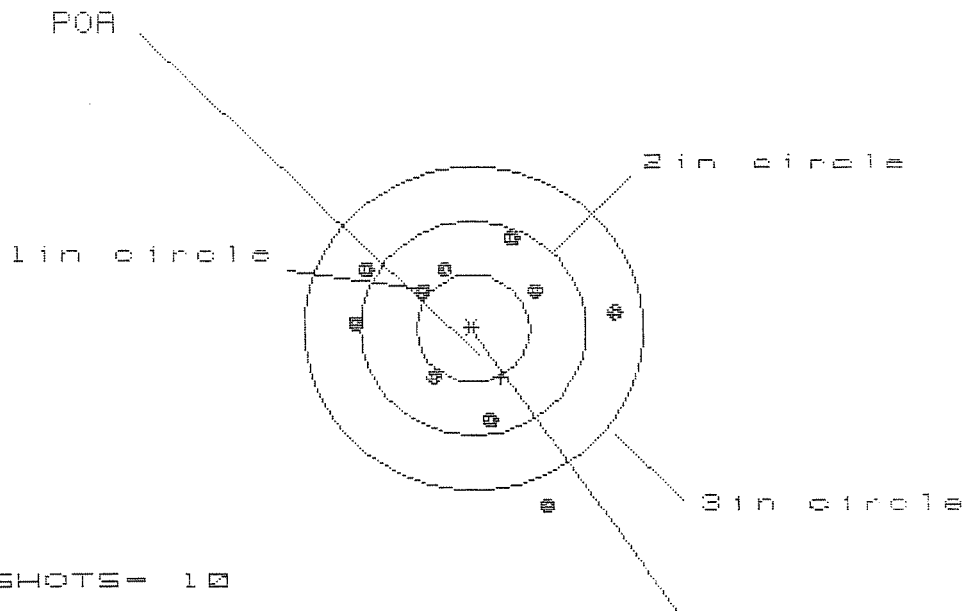
CENTROID *

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.955	.840	.914
MINIMUM X	:	-1.042	-.789	-.715
MAXIMUM Y	:	.751	.797	.712
MINIMUM Y	:	-.781	-.735	-.820
CENTROID X	:	-.378	-.263	-.337
CENTROID Y	:	.030	-.016	.069
POA TO CENTROID in.:	:	.380	.263	.344
MIN RADIUS	:	.276	.152	.259
MEAN RADIUS	:	.721	.658	.626
MAX RADIUS	:	1.120	.985	.915
HORIZONTAL SPREAD	:	1.998	1.629	1.629
VERTICAL SPREAD	:	1.532	1.532	1.532
EXTREME SPREAD	:	2.091	1.717	1.698
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 6

3 in = 9

HS= 2.254

VS= 2.482

GS= 2.619

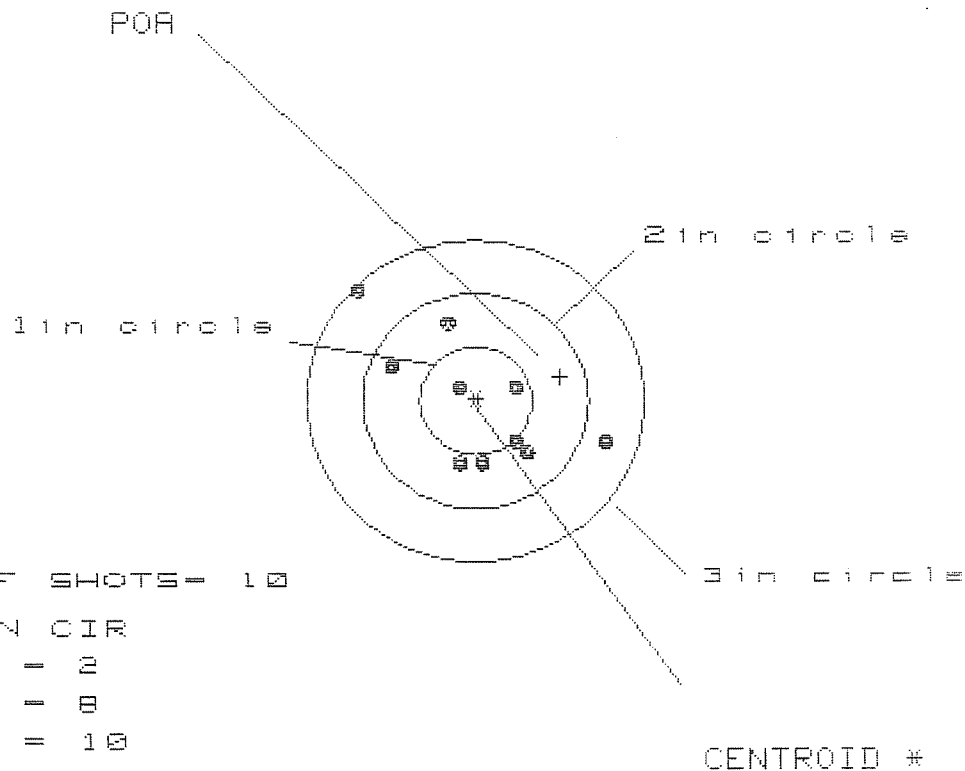
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.246	1.314	.793
MINIMUM X	:	-1.008	-.940	-.776
MAXIMUM Y	:	.859	.679	.679
MINIMUM Y	:	-1.623	-.990	-.990
CENTROID X	:	-.254	-.322	-.486
CENTROID Y	:	.449	.629	.629
POA TO CENTROID in.	:	.516	.707	.795
MIN RADIUS	:	.530	.391	.281
MEAN RADIUS	:	.911	.784	.690
MAX RADIUS	:	1.737	1.314	1.047
HORIZONTAL SPREAD	:	2.254	2.254	1.569
VERTICAL SPREAD	:	2.482	1.669	1.669
EXTREME SPREAD	:	2.619	2.258	1.686
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

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CENTERFIRE PATTERNS # 3



HS= 2.133

VS= 1.628

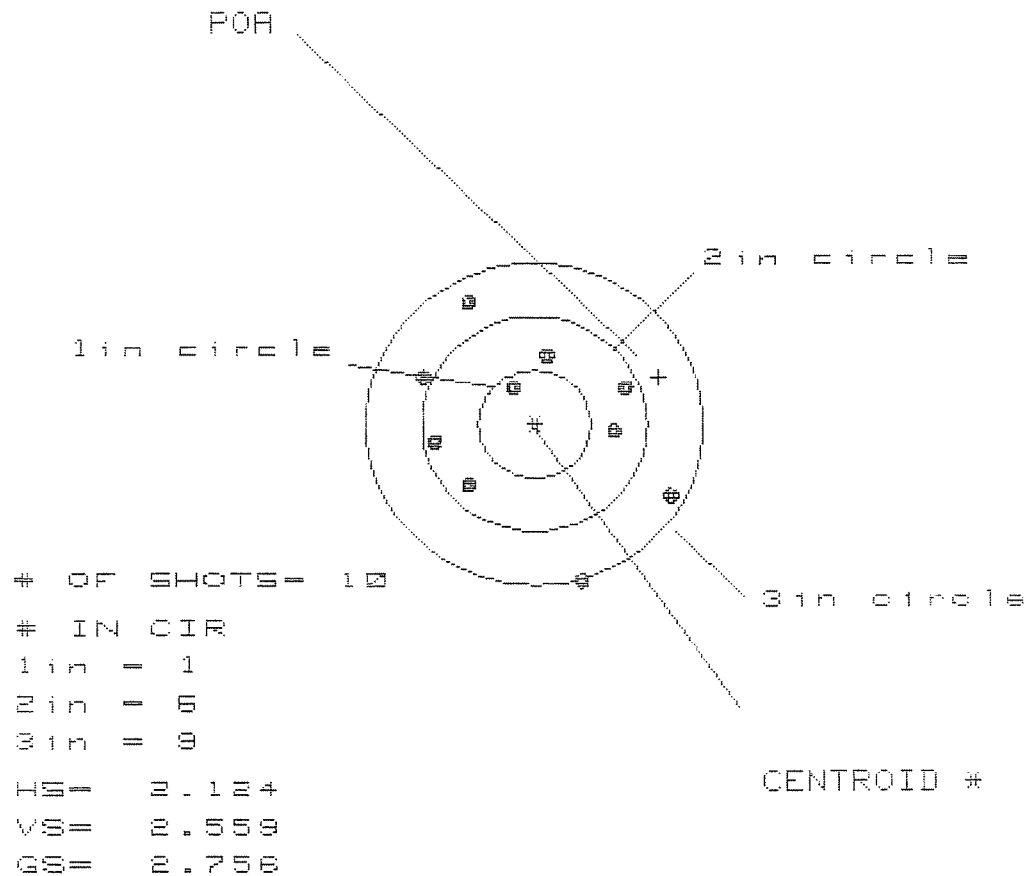
GS= 2.582

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.108	.994	.437
MINIMUM X	-1.025	-.875	-.750
MAXIMUM Y	1.062	.838	.804
MINIMUM Y	-.566	-.448	-.482
CENTROID X	-.754	-.640	-.764
CENTROID Y	-.222	-.340	-.306
POA TO CENTROID in.	.786	.725	.823
MIN RADIUS	.230	.382	.284
MEAN RADIUS	.719	.611	.560
MAX RADIUS	1.476	1.031	.837
HORIZONTAL SPREAD	2.133	1.869	1.188
VERTICAL SPREAD	1.628	1.286	1.286
EXTREME SPREAD	2.582	1.989	1.401
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

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CENTERFIRE PATTERNS # 4



PATTERN #	:	4
SHOTS (BEST OF)	:	10
MAXIMUM X	:	1.158
MINIMUM X	:	-.966
MAXIMUM Y	:	1.104
MINIMUM Y	:	-1.455
CENTROID X	:	-1.107
CENTROID Y	:	-.440
POA TO CENTROID in.	:	1.191
MIN RADIUS	:	.378
MEAN RADIUS	:	.944
MAX RADIUS	:	1.508
HORIZONTAL SPREAD	:	2.124
VERTICAL SPREAD	:	2.559
EXTREME SPREAD	:	2.756
NUMBER IN ONE INCH CIRCLE	=	1
NUMBER IN TWO INCH CIRCLE	=	6
NUMBER IN THREE INCH CIRCLE	=	9

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CENTERFIRE PATTERNS

5

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS = 10

IN CIR

1in = 4

2in = 6

3in = 9

HS = 1.914

VS = 2.633

GS = 2.746

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.700	.565	.572
MINIMUM X	:	-1.214	-.582	-.575
MAXIMUM Y	:	1.277	1.158	.973
MINIMUM Y	:	-1.356	-1.475	-.605
CENTROID X	:	.741	.876	.869
CENTROID Y	:	-.564	-.445	-.260
POA TO CENTROID in.	:	.932	.983	.908
MIN RADIUS	:	.291	.141	.109
MEAN RADIUS	:	.836	.725	.623
MAX RADIUS	:	1.621	1.476	1.055
HORIZONTAL SPREAD	:	1.914	1.147	1.147
VERTICAL SPREAD	:	2.633	2.633	1.578
EXTREME SPREAD	:	2.746	2.674	1.789
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	



VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.

MODEL 700™ M24

SERIAL NO.
C6498790

ORDER NO.
5716

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.

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